

ABSTRACT

The invention relates to a solvent-free, hot melt adhesive composition suitable for bonding a polar leather layer to a non-polar substrate, comprising:

- (a) a block copolymer having at least one A block and at least one B block, wherein:
 - (i) each A block is a mono alkenyl arene polymer block and each B block is a controlled distribution copolymer block of at least one conjugated diene and at least one mono alkenyl arene;
 - (ii) each A block having an average molecular weight between about 3,000 and about 60,000 and each B block having an average molecular weight between about 30,000 and about 300,000;
 - (iii) each B block comprises terminal regions adjacent to the A block that are rich in conjugated diene units and one or more regions not adjacent to the A blocks that are rich in mono alkenyl arene units;
 - (iv) the total amount of mono alkenyl arene in the block copolymer is about 20 percent weight to about 80 percent weight; and
 - (v) the weight percent of mono alkenyl arene in each B block is between about 10 percent and about 75 percent;
- (b) a hydrogenated hydrocarbon tackifying resin, with a softening point lower than 140°C, preferably lower than 100°C and more preferably lower than 90°C, in a weight proportion of 30 to 150 parts by weight of tackifying resin per 100 parts by weight of block copolymer and preferably from 50 to 120 parts by weight per 100 parts by weight of block copolymer;
- (c) a resin which is compatible with the mono alkenyl arene blocks, having a softening point lower than 140°C and preferably lower than 110°C, in a weight proportion of from 10 to 80 parts by weight and preferably from 20 to 60 parts by weight of resin per 100 parts by weight of block copolymer;
- (d) optionally a melt flow improving poly(alkylene) resin, which

is functionalized, in a weight proportion of from 0 to 30 parts by weight, and preferably from 5 to 20 parts by weight per 100 parts by weight of block copolymer, and

(e) stabilizers and/or additional auxiliaries in a weight proportion of from 0.1 to 1 part by weight per 100 parts by weight of block copolymer.